

Work Order ID 134246***134246***

Page 1

Item ID: D206-817-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Screw-In Windshield Modification

Start Date: 7/8/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/9/2015 Req'd Qty: 1.00

1

Customer: CAEVA02

Reference: RMA RA112039

Approvals:

Process Plan: mfDate: 15-7-22

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI9659

A

DSI9687

A

IIN-D206-817

D

100

0.00

100

QC

Quality Control

Memo

INSPECT RA112039
D206-817-011 X 1 B127405 ✓

0.00

U 15-08-07

DAS
9
9-89

DURING INSPECTION,

IT WAS FOUND THAT THE SEALANT WAS EXPIRED D4595-150-13P ✓

M119766

SCRAP AND REPLACE WITH NEW

D4595-150-13P X 1 B

119766

ID AND STOCK UNDER NEW BATCH NUMBER

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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134246

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/8/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/9/2015 **Req'd Qty:** 1.00 ***1***

Customer: CAEVA02

Reference: RMA RA112039

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

110

Identify as per dwg & Stock Location: F4033 0.00

110

Packaging

Memo

0.00

Packaging

DAS
02
9-89

ALL 12 2015

120

QC21- Final Inspection - Work Order Release	0.00
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120

QC

Memo

0.00

Quality Control

ML5

AUG 12 2015

ML3 AUG 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY				
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OTHER : _____						

Picklist Print

Wednesday, July 22, 2015 2:52:18 PM

Page 1

Work Order ID: 134246

134246

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 7/8/2015

Required Date: 7/9/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.02.14 NEW ISSUE DD VERF: IPP REV:B
12.05.09 AS PER IIN REV.C DD VERF:EC IPP REV:C 12.06.12
ECN 12-602 DD VERF:EC IPP REV:D 13.04.23 as per IIN
dwg rev.D DD verf:JLM IPP REV:E 13.06.26 as per
CHG004/DSI9659 DD VERF:JFS IPP REV:F 14.03.24 AS PER DSI 9687
DD VERF:JLM IPP REV:G 15.01.06 now @ chg006/ecn14-547 DD
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-817-011		Manufactured	No				Each	1.0000		1			
D206-817-011									**				
Screw-In Windshield Modification													

Location

FG033

Loc Qty

1

Loc Code

MF 15-7-22

127405

1

D4515-150-13P x 1 B 119766

expiration 06/10/2015

Smb
15/9/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

RA112039

Received @ June 30, 2015
Inspected@ July 2, 2015

CUSTOMER: AIR-EVAC/BELL HELICOPTERS
CUSTOMER CONTACT: BERVERLY GREGORY/
LEA SMITH
SHIPPED FROM: PINEY FLATS, TENNESSEE USA

Instructions for RA112039 D206-817-011 B127405 CHG 006

- During inspection of D206-817-011, it was notice that sealant tape D4595-150-13P M119766 was expired
- Scrap D4595-150-13P M119766 and replace
- Rest of kit is inspected and complete
- Restock D206-817-011 with new batch number
- Had new labels and paper work

Time Estimate: 1 hour

Departments Required: quality, stores

Pictures Attached: N/A

QTY INSPECTED: 1x D206-817-011 B127405 CHG 006

**THIS INSTRUCTION SHEET
MUST BE ATTACHED TO THE
RESTOCKING WORK ORDER
AT ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Doc/Data ☐	Offset/Setup ☐																																																																			
Equip/Tooling ☐	Supplier ☐																																																																			
Handling/Pre ☐	Training ☐																																																																			
Material ☐	Use for Testing ☐																																																																			
Internal Transport ☐	Poor Information ☐																																																																			
Tribal Knowledge ☐	Rushing ☐																																																																			
LOA ☐	Product Improvement ☐																																																																			
Substation ☐	Process Improvement ☐																																																																			
Past Expiry Date ☐	Manufacturing Process ☐																																																																			
Misidentified ☐	Past Due ☐																																																																			
Pressure/Forced ☐	Temperature/Cure ☐																																																																			
Bending ☐	Set-up ☐																																																																			
Centre Not Concentric ☐	BOM/Route ☐																																																																			
Cracks ☐	Broken/Damage/Defect ☐																																																																			
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐																																																																			
Cuffs ☐	Contamination ☐																																																																			
Crushing ☐	Countersink ☐																																																																			
Heat Treat ☐	Cut Too Short ☐																																																																			
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐																																																																			
Marks/Chatter ☐	Drill Holes ☐																																																																			
Power Loss/Surge ☐	Positioned Wrong ☐																																																																			
Folio/Program ☐	Outside Dimensions ☐																																																																			
Grain ☐	Over/Under tolerance ☐																																																																			
Weld ☐	Part Incorrect ☐																																																																			
Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																			
Out of Sequence ☐	Part Moved ☐																																																																			
Off-set ☐	Drawing ☐																																																																			
Mislabeled ☐	Finish ☐																																																																			
Fit/Function ☐	Misread ☐																																																																			
Misaligned/off center ☐	Turning Sequence ☐																																																																			